

Date: Tuesday, 16/10/2007 12:33:40 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-612
Job Number	: 35180		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D206642612
This Issue	: 16/10/2007 S.O. No. : N/A	Drawing Number	: RTN635
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/10/2007 Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 35179	Material	: N/A
Written By	: _____	Due Date	: 23/10/2007
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: _____		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 635

2.0

D206642612

Skidtube RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Skidtube LH
 ORIGINAL B/N 31964

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 DO NOT REPACKAGE, LEAVE AS IS
 RED TAG - HOLD FOR
 REWORK SCHEME FROM ENG.

4.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 ST-10-24
 closed in QRTN

Date: 24/12/2007, 12:10:19 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-642-612
 Job Number : 35180
 Estimate Number : 10804
 P.O. Number :
 This Issue : 24/12/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 16/10/2007 Type : LANDING GEAR
 Previous Run : 35179
 Written By :
 Checked & Approved By :
 Comment :

Part Number : D206642612
 Drawing Number : RTN635/ECN 1070
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 23/10/2007 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-612	CHG	CHG002-
DESC.	Float Skidtube RH	STC	SH98-4
LOT	B31964	STC	SA00475SE
MODEL	Bell 206A/B	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Seq. #: Machine Or Operation:

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 635

2.0

D206642612

Skidtube RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Skidtube LH
 ORIGINAL B/N 31964

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install
 plug
 and

- a). Drill out existing mid float welded spacers. 3 spacers per skidtube
 b). Fill drilled out holes with weld. 6 holes total
 c). Drill new mid float bag holes (on an angle) per D3288 Rev F. 12 places per skidtube

M 106330

(weld rod)

M 105671

(plus)

6051-16

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 080205 ①

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/12/05 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE ALL EXISTING PARTS
SAND LIGHTLY FOR RE-PAINT

DP
08-02-08 (X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

RE-PAINT PER QSI005

FL *08/02/08*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-11

(X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.

e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places (2x) *D3272-1/B34470*

INSTALL ALL EXISTING PARTS (WEARPLATES ETC) PER DRWG D3288 REV.F

INDICATE ANY NEW PARTS USED:

1- D3535-21/B31991

1- D3536-41/B31997

1x D2646

1- 3535-15/B36653

1- D3535-15/B33964

B36184

66-AN3C-4A/M107008

(2x) NAS1515H3L

66-AN960C-10L/M107008

M10516

yl

11.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

INSERT

B36319

yl *08-02-11*

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

SCREW

(OR AN3C3A)

M107008

~~M107008~~

11

13.0

AN960C10L

washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

washer

M107008

11

08-02-11

KL

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/12

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PICK NEW PACKING KIT:

16.0

D206651041

206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

1 D206651041 GHW Kit

Batch:

B31296

AS

08/02/12

KL

17.0

D26652

Saddle, RH, Fwd, Aft, Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-2 Saddle

B32696x1

* No quantity ramp

B32693x1

AS

08/02/12

KL

18.0

D26662

Saddle, RH, Fwd, Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-2 Saddle

34781

AS

08/02/12

KL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-02-11	B.1	spray both side of I-Beam w/ WPS-3 M106096	HL	08-02-11	1		S 08/02/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652

Bushing

38031

AS 08/02/19 (X)

20.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

B34628

AS 08/02/19 (X)

21.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

35497

AS 08/02/19 (X)

22.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

B34782

AS 08/02/19 (X)

23.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

B36336

AS 08/02/19 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M106541 x 5

M106297 x 1

AS 08/02/19

(XU)

25.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

HIGH STEEL BOLT

batch

M106277

AS 08/02/19

(XU)

26.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

PHENOLIC WASHER

batch

B34470

AS 08/02/19

(XU)

27.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

M105426

AS 08/02/19

(XU)

28.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batc

4 AN5C7A Bolt

19185

AS 08/02/19

(XU)

29.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt

M105634

AS 08/02/19

(XU)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:19 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M105156

AS 08/02/19 (XU)

31.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C35A Bolt M18918

AS 08/02/19 (XU)

32.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

bolt

batch

M100516

AS 08/02/19 (XU)

33.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN6C44A Bolt ~~M100516~~ 106602

AS 08/02/19 (XU)

34.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch

M105898

AS 08/02/19 (XU)

35.0

AN960C10L

washer



Comment: Qty.: 30.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN960C10L Washer M107008

AS 08/02/19 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:20 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer

M105793

AS 08/02/19 (X1)

37.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer

M103344

AS 08/02/19 (X1)

38.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt

M19185

AS 08/02/19 (X1)

39.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut

M107214

New Batch

AS 08/02/22 (X1)

40.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut

M106763

AS 08/02/19 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:20 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5 Nut

M165430

AS 08/02/19 (X1)

42.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut

103693

AS 08/02/19 (X1)

43.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch

106167

AS 08/02/19 (X1)

44.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch

B36319

AS 08/02/19 (X1)

45.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch

B35522

AS 08/02/19 (X1)

46.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch

B35521

AS 08/02/19 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 24/12/2007 12:10:20 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-612

Job Number: 35180

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch 34471

AS 08/02/19 (X1)

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch M106574

AS 08/02/19 (X1)

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/25
chg003 } put in box

(1)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-612

USING NEW B/N

CHG 003

Location:

PPP Rev: C

8/2/25 SV (1)

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/25

Job Completion



mi 2008/2/25 (1)

B 35180

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Peter Hum [phum@dartaero.com]
Sent: December 21, 2007 11:33 AM
To: 'L Lacelle'
Subject: RE: ECN1070 / 1063 for change record #003

Hi Linda,

I am writing this re-work with the assumption that the float skidtubes are painted and basically complete per the old CHG

Therefore to re-work these to CHG 003

- a) Drill out existing mid float welded spacers. 3 spacers per skidtube
- b) Fill drilled out holes with weld. 6 holes total
- c) Drill new mid float bag holes (on an angle) per D3288 Rev F. 12 places per skidtube
- d) Install D3683-1 inserts. Plug inserts with MS27039C1-05 (or AN3C3A bolt) and AN960C10L washers. 12 places per skidtube.
- e) On the aft cap, replace the NAS1515H3L with D3672-1 washers. 2 places

Changes to "pick" kit

- a) REMOVE NAS1515H5 washer replace with D3672-5. Qty 16
- b) REMOVE NAS1515H5L washer replace with D3672-7. Qty 8
- c) REMOVE NAS1515H4L washer replace with D3672-3. Qty 24
- d) ADD MS21250-03004 bolt. Qty 6
- e) REMOVE NAS1515H3L washer replace with D3672-1. Qty 18
- f) ADD AN960JD10 washer. Qty 6

For reference please see D3288 Rev. F and Installation Instructions D206-642 Rev. L

Peter

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: December 20, 2007 2:46 PM
To: Peter Hum (Peter Hum)
Subject: FW: ECN1070 / 1063 for change record #003

Peter,
Could you please let me know what the rework scheme will be...642-641's returned from airlog/offshore

Thx
LL

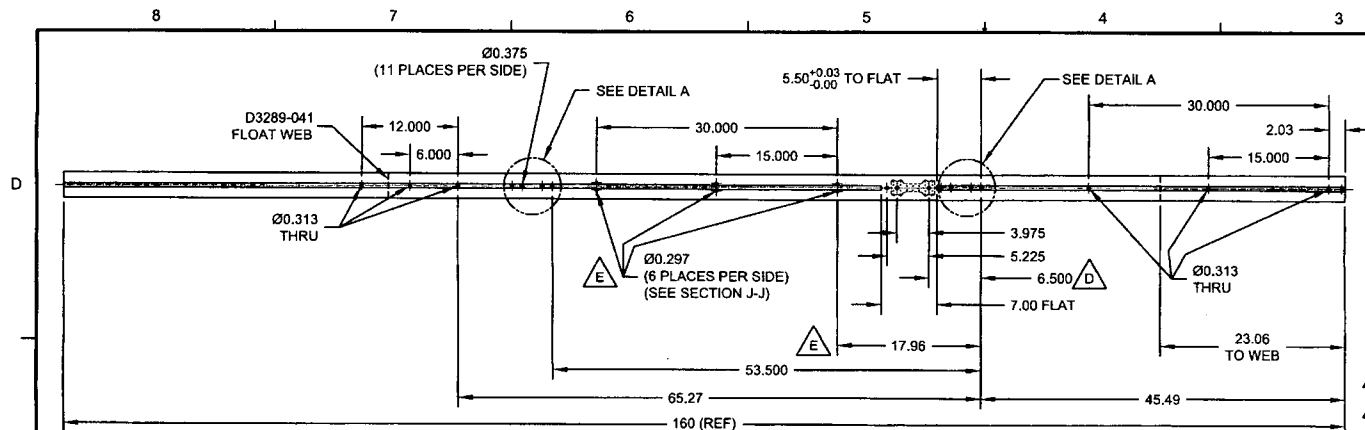
-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: December 20, 2007 1:50 PM
To: Linda Lacelle (E-mail)
Subject: ECN1070 / 1063 for change record #003

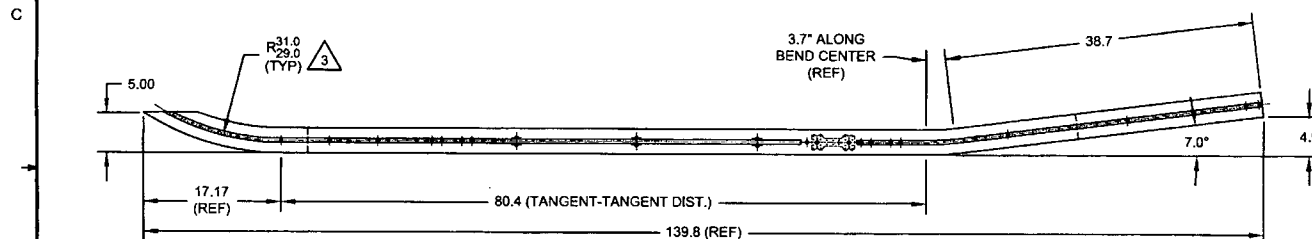
Linda,

All four skidtubes need to be reworked, B35179, 35180, 36159, 36160 per ecn 1070

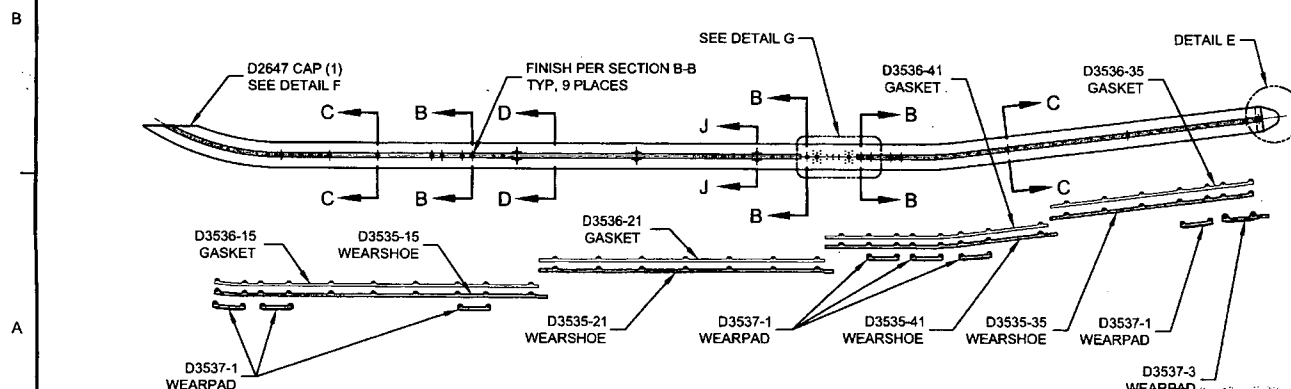
Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
Email: kjohnston@dartaero.com



D3288-041 DRILLINGWEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN600CA16	WASHER
78	AN600C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3288-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES.
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- WELDING: PER DART QSI 004.

F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	DL		
CHECKED	DL		
MFG. APPR.	RP		
APPROVED	RP		
DE APPR.	RP		
DATE	07.11.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY SCALE 1:15 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

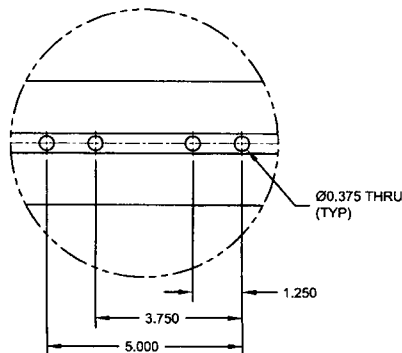
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

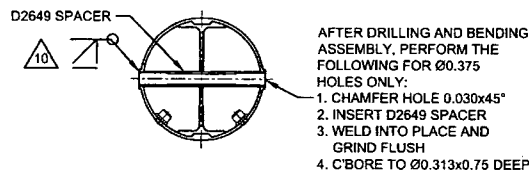
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

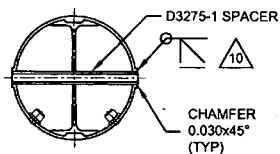
NOTE: Date & initial all entries



DETAIL A: DRILL DETAIL



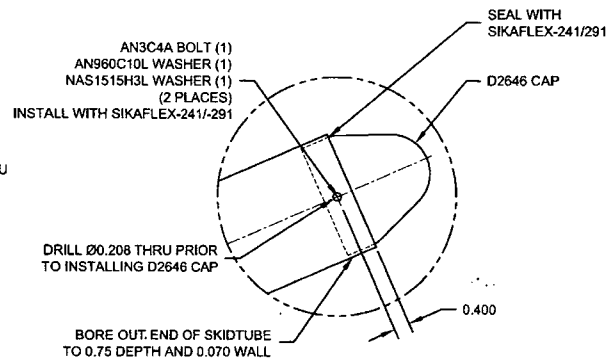
SECTION B-B
FOR Ø0.375 HOLES ONLY
(TYP, 9 PLACES)



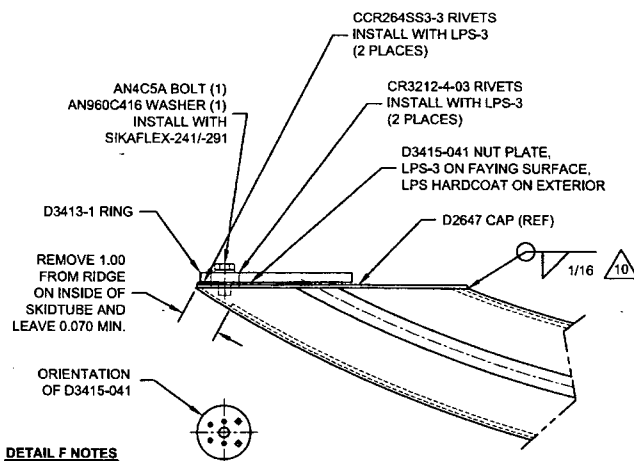
SECTION C-C
FOR Ø0.313 HOLES ONLY
(TYP, 6 PLACES)



SECTION D-D
FOR WEARSHOES INSTALL ONLY
(TYP, 32 PLACES)



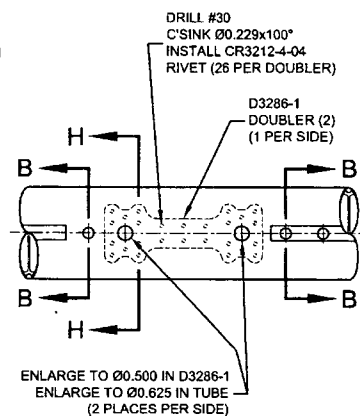
DETAIL E



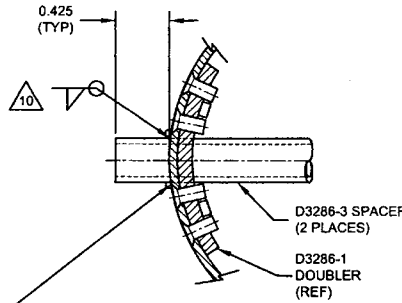
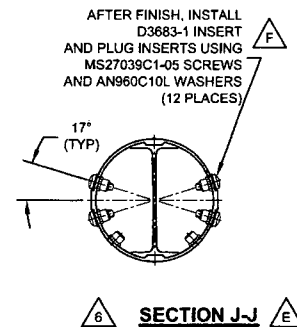
DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL



DETAIL G
SCALE 1:5



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION H-H
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. F
MFG. APPR.	AB	D3288	SHEET 2 OF 2
APPROVED	AB	TITLE	SCALE
DE APPR.	AB	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

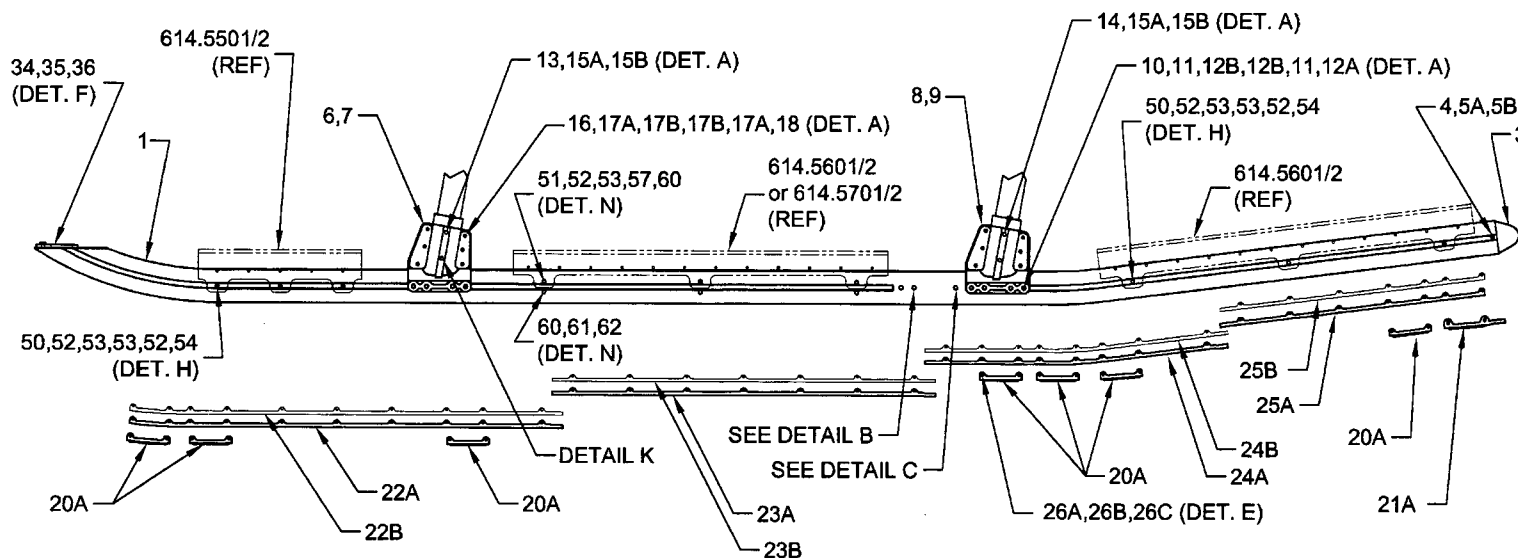
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

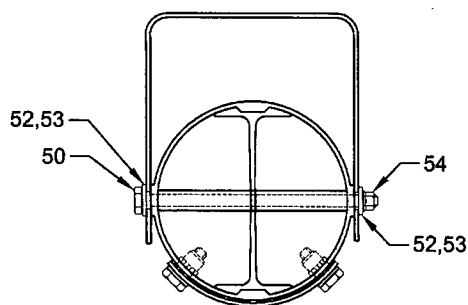
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

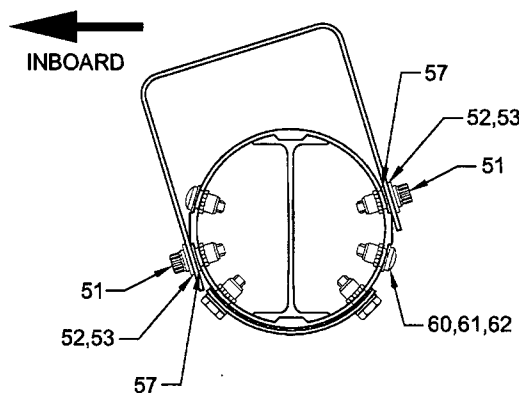
206 A/B FLOAT SKIDTUBES (TRI-BAG FLOATS) (D206-642-611/-612/-613/-614)



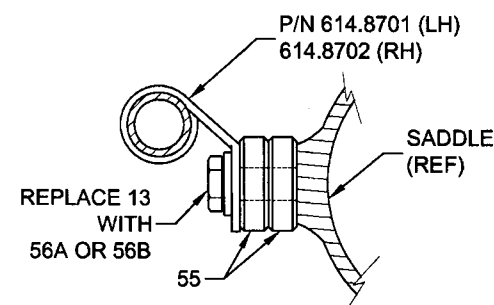
DETAIL H



DETAIL N



DETAIL K



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

Revision: **L**
Date: 07.10.25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 8:46:33 AM
 User: John Johnston

Process Sheet

43

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642-612
Job Number : 35180	
Estimate Number : 10804	
P.O. Number :	Part Number : D206642612
This Issue : 1/7/2008 S.O. No. :	Drawing Number : RTN635/ECN1070
Prsht Rev. : NC	Project Number :
First Issue : 10/16/2007 Type : LANDING GEAR	Drawing Revision :
Previous Run : 35179	Material :
Written By :	Due Date : 10/23/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Bluehills 08.01.11 *[Signature]*

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

46.0	D36725	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
 PHENOLIC WASHER
 batch _____

47.0	D36723	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
 PHENOLIC WASHER
 batch _____

48.0	MS27039C105	SCREW
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
 SCREW
 batch _____

49.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D206-642-612
 USING NEW B/N
 CHG 003
 Location: _____
 PPP Rev: _____

REFERENCE ONLY